

Date: Thursday, 19/02/2009 11:50:06 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BASKET RIB
<b>Job Number</b> : 45895	
<b>Estimate Number</b> : 10402	
<b>P.O. Number</b> :	<b>Part Number</b> : D31661
<b>This Issue</b> : 19/02/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3166 REV.A2
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : A2
<b>Previous Run</b> : 45779	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 25/02/2009 <b>Qty:</b> 12 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 09.02.19</u>	
<b>Comment</b> : Est. A 02.08.23 New issue KJ	
Est. B 08.12.05 Updated bending program on step 3 per NCR	
W/O43165 KJ Verified by: EC	
Est Rev:C 09-01-23 as per DEO D3166-A2 DD verified by:EC	

## Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

M304TS0750W065

304 SQ Tube .75x.75x.065W



Comment: Qty.: 5.2500 f(s)/Unit Total : 63.0000 f(s)

304 SQ Tube.75x.75x.065W

(M304TS0750W065)

Material: 304/316 SS tube 0.065" wall

Batch M110239

SAD 09-02-23

2.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Cut 3/4" x 3/4" square tubing 60.00" long.

SAD 09-02-23 (12)

3.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

-Form D3166-1 Basket Hoop as per Dwg D3166 using Bending program 350 BASBE, and folio FT004.

9-2-24

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect Basket Hoop dimensions with template D3166-1-T1 (DT8302)

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_





SAD 09-02-24 (11)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3166-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 17 Date: 09/02/25

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>45895</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-02-24	30	1 part scrap. Does not fit in the jig. Experiment part to modify & perfect the program. P.C. program revision.		Scrap & destroy. No replace	SAD 09-02-24			

NOTE: Date & initial all entries

Date: Thursday, 19/02/2009 11:50:06 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET RIB

Job Number: 45895

Part Number: D31661

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/25 *AD*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*MR* 09-02-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

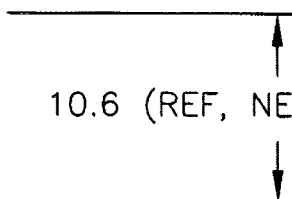
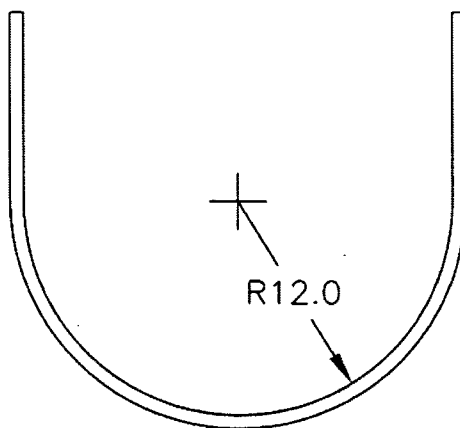
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3166	REV. A SHEET 1 OF 1
DATE 02.07.10		TITLE BASKET HOOP	SCALE NTS
A	02.07.10	NEW ISSUE	
A1	04.04.08	38+/-1 was 36.0	

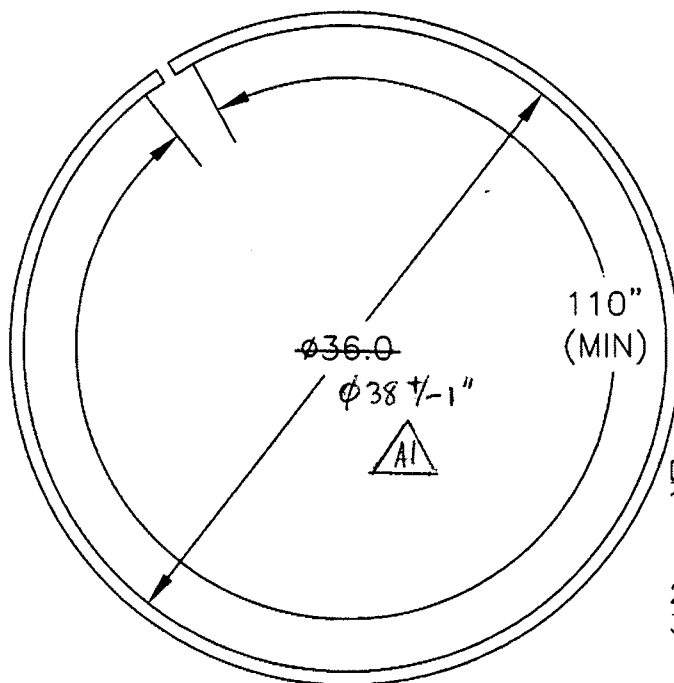
RELEASED  
02.08.06



10.6 (REF, NEED 8.0 MIN)

D3166-1 BASKET HOOP

- 1) MATERIAL: AISI 304/316 SS SQUARE TUBING,  
0.75" x 0.75" x 0.063 WALL, 60.00" LONG  
(REF DART SPEC. M304TS0.750W.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED



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WITHOUT NOTICE  
WORK ORDER  
NO. 45895

D3166-3 BASKET HOOP

- 1) MATERIAL: AISI 304/316 SS SQUARE TUBING,  
0.75" x 0.75" x 0.063 WALL, 120.00" LONG  
(REF DART SPEC. M304TS0.750W.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED

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DRAWING NO. D3166	TITLE BASKET HOOP	REV.A1	<b>DART AEROSPACE LTD ENGINEERING ORDER</b>		D.E.O. NO. D3166-A-2	SHEET NO. 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 08.12.11	DATE 08.12.15	DATE 08/12/15	DATE 08/12/16		DATE 08.12.16		

1) MODIFY MATERIAL NOTE FOR D3166-1 AS SHOWN:

IS:

1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING,  
60.00" LONG  
REF. DART SPEC M304TS0.750W.065

WAS:

1) MATERIAL: AISI 304/316 SS SQUARE TUBING,  
0.75" x 0.75" x 0.063 WALL, 60.00" LONG  
(REF DART SPEC. M304TS0.750W.063)

2) MODIFY MATERIAL NOTE FOR D3166-3 AS SHOWN:

IS:

1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING,  
120.00" LONG  
REF. DART SPEC M304TS0.750W.065

WAS:

1) MATERIAL: AISI 304/316 SS SQUARE TUBING,  
0.75" x 0.75" x 0.063 WALL, 120.00" LONG  
(REF DART SPEC. M304TS0.750W.063)

REASON: SEE PAR 08-005

NO. *[Signature]*  
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